

Date: Thursday, 12/21/2006 12:01:09 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION  
 Job Number : 30062  
 Estimate Number : 10305  
 P.O. Number : *UHA* Part Number : D2423  
 This Issue : 12/21/2006 S.O. No. : *UHA* Drawing Number : D2423 REV B1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *UHA* Type : PURCHASED PARTS Drawing Revision : B1  
 Previous Run : 23779 Material : *UHA* Due Date : 1/2/2007 Qty: *405* (360) Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est G 04.09.02 Part Number D2423-108 changed to D2423KJ/J LM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	D2423P	Lug Extrusion
Comment: Qty.: 1.0000 f(s)/Unit Total : 360.0000 f(s) <i>→ 405'</i> Lug Extrusion <i>1206112122 (360 FT)</i>		
3.0	PACKAGING 1 <i>ENSURE QCR 1</i>	PACKAGING RESOURCE #1 <i>7/10/11 (45 mcp) 405 SPIM</i>
4.0	QC6	DIMENSIONAL CHECK <i>07.01.17 (45) 405</i>
5.0	PACKAGING 1 <i>CNC</i>	PACKAGING RESOURCE #1 <i>07.01.17 405</i>
6.0	QC21	FINAL INSPECTION/W/O RELEASE <i>(405)</i>
Comment: FINAL INSPECTION/W/O RELEASE <i>07107118</i>		
Job Completion <i>U 07-01-18</i>		



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ED Date: 07/01/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

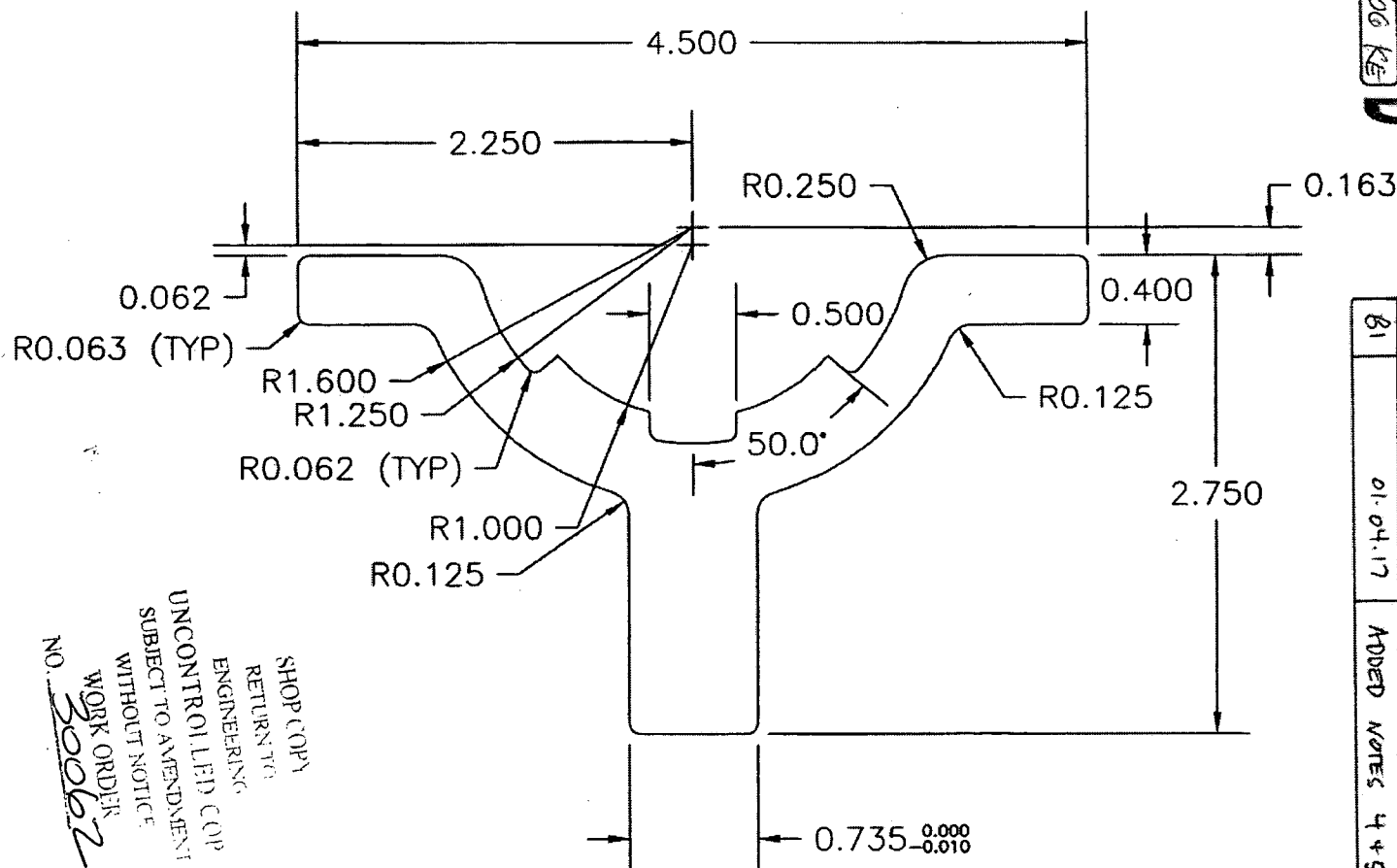
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QA COPY

RELEASED  
98/08/06 KE

DESIGN LE	DRAWN BY KE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. B
CHECKED RBD	APPROVED KE	DRAWING NO. D2423	SHEET 1 OF 1	
DATE 98.08.04		TITLE LUG EXTRUSION	SCALE 1:1	
A	95.05.09	NEW ISSUE		
B	98.08.04	6061-T6 WAS 6005A.T5		
B1	01.04.17	ADDED NOTES 4+5 <i>4 CP</i>		



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARADON INDALEX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ONT

EXPÉDIÉ / SHIP TO

INDICATIONS SPÉCIALES  
SPECIAL INSTRUCTIONS

P/S#: 584422

VOTRE NUMÉRO DE COMMANDE  
OUR ORDER NO

6122430 1

MÊME - SAME

K6A1K7

CUSTOMER P.S.T. : \*6122-5207

INDALEX G.S.T. REG NO: R136834041

Required Date:

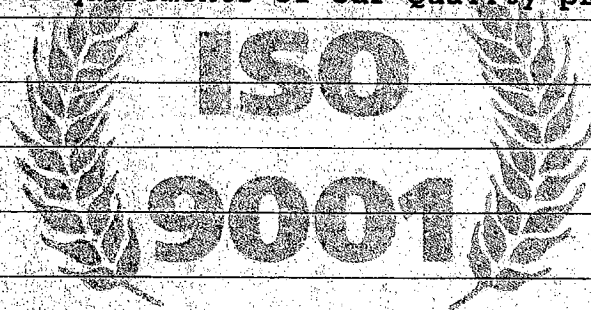
DU CLIENT CUST NO 201355	TPS G.S.T. XXXXXX	TAXE DE VENTE PROV. PROV. SALES TAX	N° DE COMM. DU CLIENT CUST. ORDER NO 2770	DATE DE COMMANDE ORDER DATE 6/12/22	NOTRE DATE DE COMM. OUR ORDER DATE 6/12/22	CONDITIONS TERMS
ENDEUR ALES MAN 51	EXPÉDIÉ PAR SHIP VIA NOTRE CAMION OUR TRUCK	PAYÉ P.D. X	PERC. C.O.D. X	C.A.D. C.O.D. X	F.A.B. F.O.B. X	NOTRE USINE OUR PLANT
EN BALLOTS BUNDLED AND TAPED		CARTONNÉ CARTONED		CARTONNÉ & INTERCALE CARTONED & INTERLEAVED		

DATE DE LIVRAISON  
DATE SHIPPED  
7/01/11

ENVOYÉ PAR  
SHIPPED VIA  
OTTAWA 12 JAN.

QUANTITÉ QUANTITY	CHARGÉ CHARGE	N° DE MATRICE INDALEX D E NO	DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION	ALLIAGE ET TREMPAGE ALLOY AND TEMPER	LONGUEUR LENGTH	PRIX UNITAIRE UNIT PRICE
			F EXTRUDE ONLY DUE=2007/01/17 ASAP			
1	622	40	MS 18866 D2423 LUG EXTRUSION BUNDLE= 741830 741832	6061 T6	2743	

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures



*[Signature]*

COMMANDE / ORDERED			CETTE EXPÉDITION THIS SHIPMENT			MONTANT AMOUNT
POIDS WEIGHT	PIÈCES PIECES	BALLOTS BOLLS	POIDS WEIGHT	PIÈCES PIECES		
0	0	2	692	45	POIDS EN KGS	

*[Signature]*



INDALEX LIMITED  
 325 AVRO Street  
 POINT-à-CLAIRE, QC H9R 5W3  
 TELEPHONE: (514) 697-5120 & (800) 563-5120  
 FACSIMILE: (514) 694-8310 & (800) 563-8310

## FACSIMILE TRANSMITTAL SHEET

TO: Christina Young

FROM: Bruno Morency  
Quality Technician

COMPANY:

DART AEROSPACE LTD

DATE:

2007/01/11

FAX NUMBER:

1(613) 632-4443

TOTAL NO. OF PAGES INCLUDING COVER:

2

PHONE NUMBER:

SENDER'S REFERENCE NUMBER:

SUBJECT:

REPORT

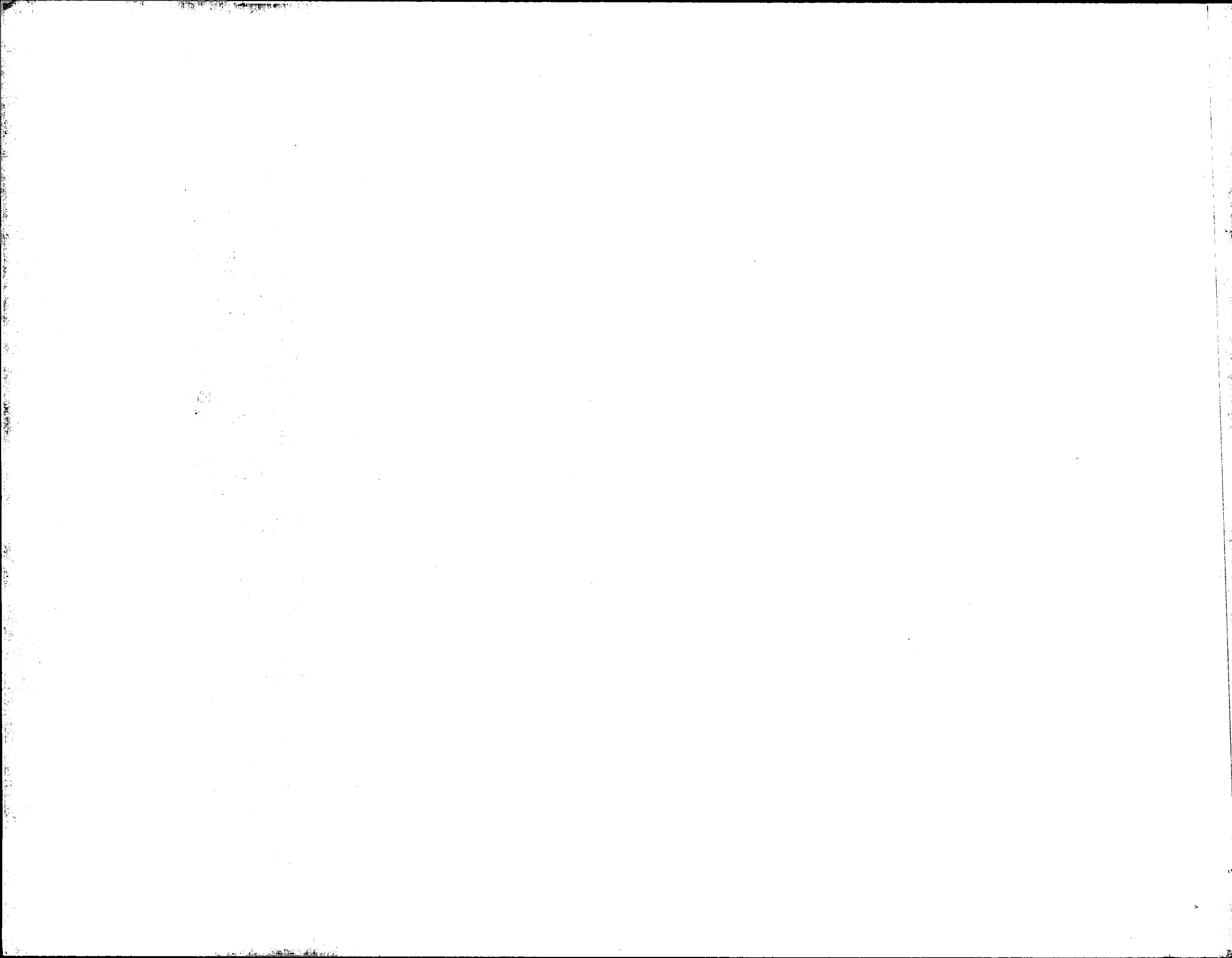
TIME:

☐ URGENT ☐ FOR REVIEW ☐ PLEASE COMMENT ☐ PLEASE REPLY ☐ PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical properties report.

THIS COMMUNICATION IS INTENDED ONLY FOR THE PARTY NAMED BELOW AND MAY CONTAIN INFORMATION THAT IS PRIVILEGED AND CONFIDENTIAL. IF YOU ARE NOT THE INTENDED RECIPIENT OR THE PERSON RESPONSIBLE FOR DELIVERING THIS COMMUNICATION TO THE INTENDED RECIPIENT, YOU ARE HEREBY NOTIFIED THAT ANY DISCLOSURE, COPYING, DISTRIBUTION, OR THE TAKING OF ANY ACTION IN RELIANCE UPON THE CONTENTS OF THIS COMMUNICATION IS STRICTLY PROHIBITED. IF YOU HAVE RECEIVED THIS COMMUNICATION IN ERROR, KINDLY NOTIFY THE SENDER IMMEDIATELY BY TELEPHONE AND RETURN THE ORIGINAL TO US BY MAIL.





325 rue AVRIL  
Pointe-Clair QC H9R 5W5

Téléphone (514) 697-5120  
Fax-simile (514) 694-8310

## Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD  
Adresse / Address : 1270 ABERDEEN STREET  
HAWKESBURY ONT,  
K6A 1K7

# commande Indalex / Indalex order # : 6122430

# bon de commande / Purchase order # : 2770

# de matrice / Die # : MS 18868 Description: LUG EXTRUSION

Alliage & trempage / Alloy & temper : 6061 T6

# Contrôle / Control # : 36341-1

# Coulée / Cast # : 36731

	Min. requise Min. required	Valeur testé Actual results
Tension ultime Ultimate stress (psi)	58 000	49280
Contrainte élastique Yield stress (psi)	35 000	36676
% élongation dans 2"	8	12.5
Dureté Rockwell E (Hr)	58 @ 100	55

### Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.40 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.48 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.82	0.03 Max	0.05 Max	0.03 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6061	0.7 - 1.3	0.6 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	—	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 et AMS QQA 200/8 ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 and AMS QQA 200/8 standard and requirements of our quality control procedures.

Sincèrement vôtre,  
Yours truly,

Date : 2007-01-11

Bruno Morency  
Technicien de la qualité  
Quality technician

Indalex Limited